

Work Order ID 50176

July 10, 2009 7:45:29 AM



Page 1

Item ID: D3407-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Tow Ring

Start Date: 07/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 09-07-10 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3407

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI
004 A/R TIG174 ROD Batch: M101972

EL 9-7-9

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

09-07-10

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 509/6/10 counts 420

013

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Page 2

Item ID: D3407-043

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Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

Mask Threaded Section START TIME:
TEMPERATURE: 8:20am FINISH TIME:

400°F 110VEN
8:50am

111248 07-07-13

(20) 20

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09-07-13

(20)

20

150

Identify as per dwg & Stock Location:

464

0.00



Packaging

Memo

0.00

Packaging

9/11/13

(20)

SD

Work Order ID 50176



Page 3

July 10, 2009 7:45:29 AM

Item ID: D3407-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Tow Ring

Start Date: 07/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/14

U 31-07-14

Picklist Print

July 10, 2009 7:45:29 AM

Page 1

Work Order ID: 50176

Parent Item: D3407-043RevE

Parent Item Name: Tow Ring


Comments:

Start Date: 07/10/2009

Required Date: 07/17/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3407-3RevE		Manufactured	No			100	Each	40.0000	20.0000			
												
Stem												


Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 40

46041 12

48357 28

D3407-5RevE		Manufactured	No			100	Each	31.0000	20.0000			
												
Ring												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 31

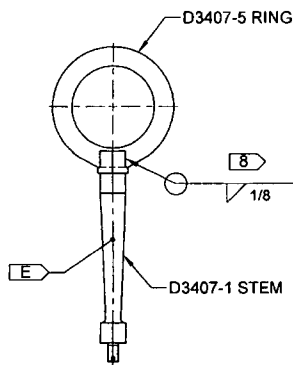
47347 2

48546 29

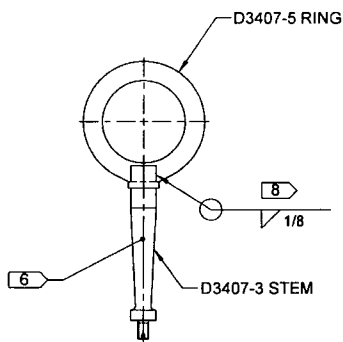
12 EL 9-7-10
8

2 EL 9-7-10
18

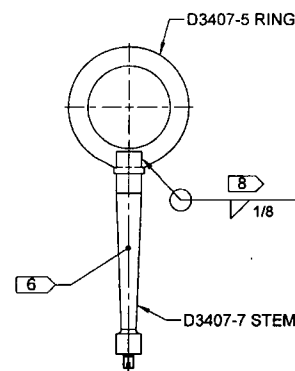
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



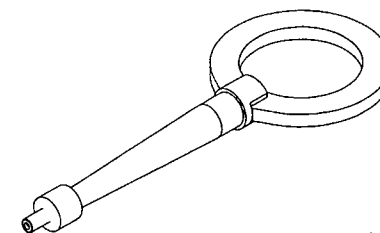
D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING



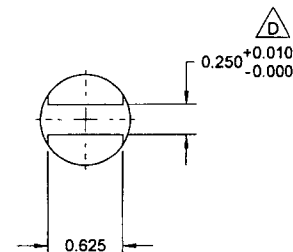
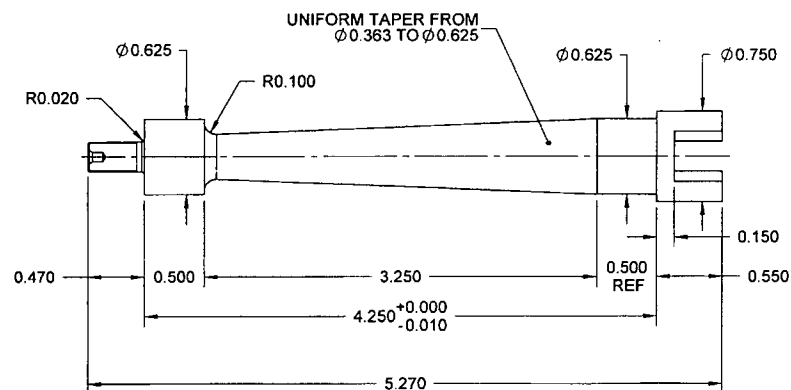
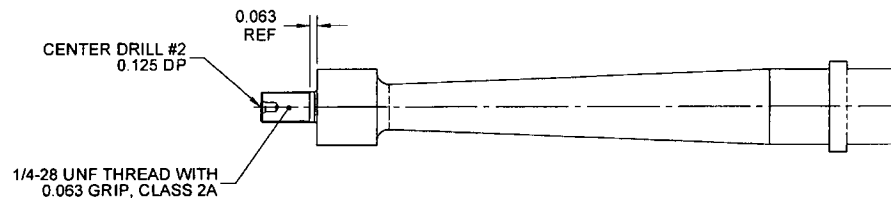
#50176
mf

RELEASED

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3407 TITLE TOW RING SCALE NTS <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
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CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.23		



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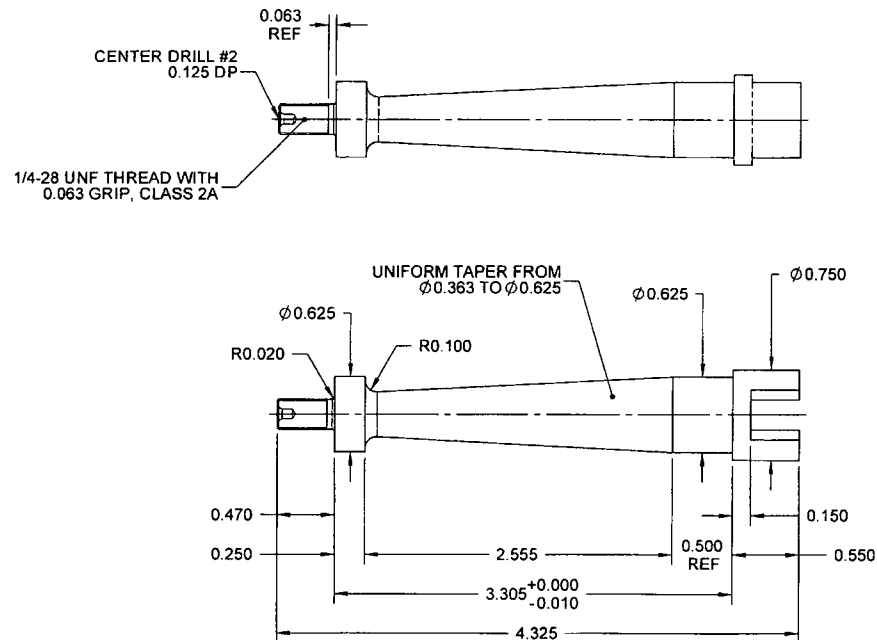
D3407-1 STEM

RELEASED
08-07-23

NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

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D3407-3 STEM

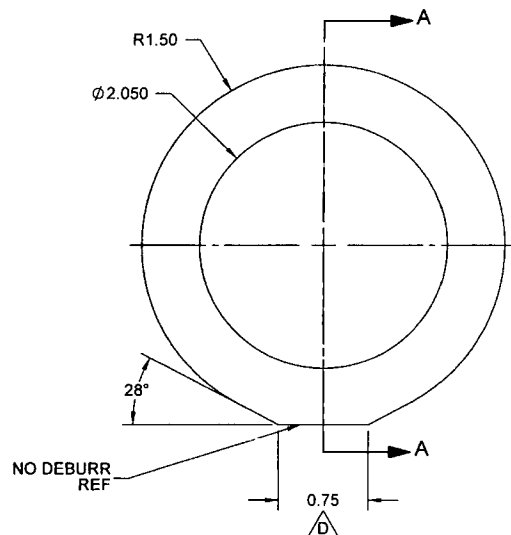
NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

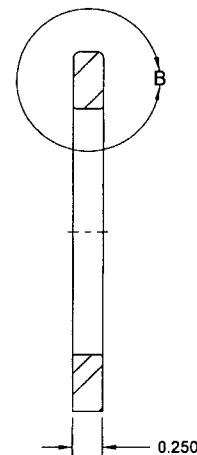
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DE APPR.		TOW RING	NTS
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08-08-01 MFB

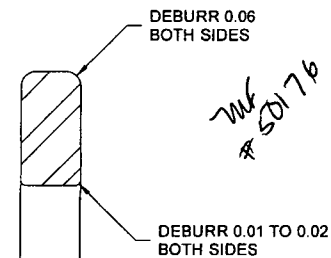
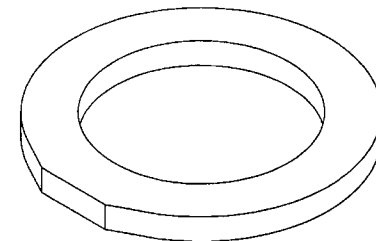
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50176



D3407-5 RING



SECTION A-A



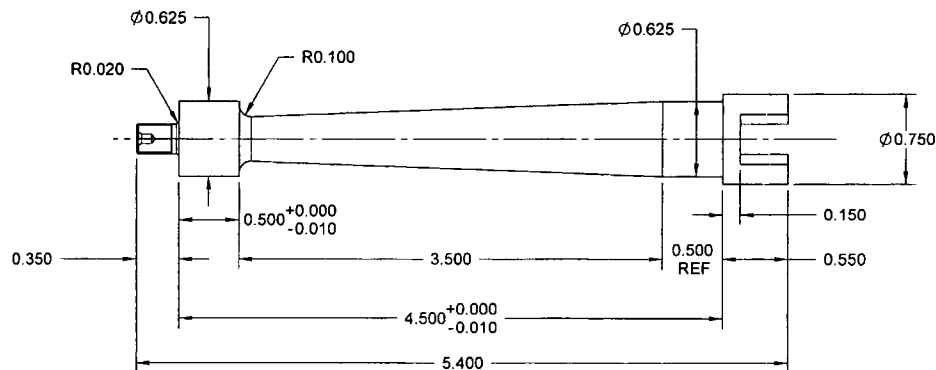
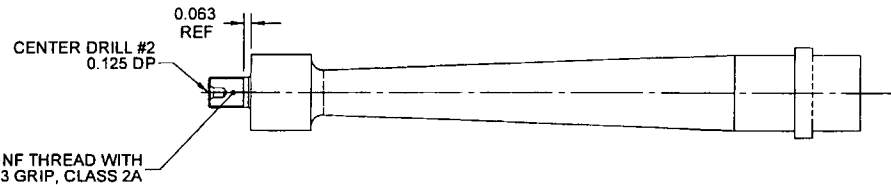
DETAIL B
SCALE 2X

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08-08-21/11/11

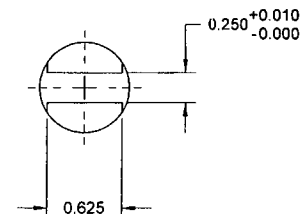
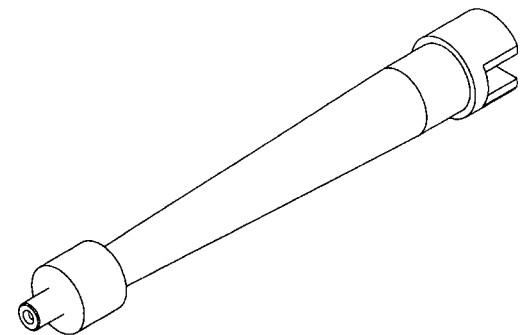
- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

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DE APPR.		TOW RING	NTS
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8 7 6 5 4 3 2 1




D3407-7 STEM



mf
#50176

RELEASED
DA-01 MP

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

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8 7 6 5 4 3 2 1